

Work Order ID 117788

117788

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May-02-14 11:12:15 AM

Item ID: D5046-043 Accept *N900040100* Setup Start *NS1*

Revision ID: Stop *NS2*

Item Name: Co-Pilot Collective Head Assembly (212)

Start Date: 5/02/14 Start Qty: 1.00 *1* Cust Item ID:

Required Date: 5/16/14 Req'd Qty: 1.00 *1* Customer:

Reference:

Approvals: Process Plan: MCS Date: 140502 Tooling: _____ Date: _____ Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|---|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| Draw Nbr | Revision Nbr | | | | | | | | |
| D5046 | A | | | | | | | | |
| 110 | Weld per dwg A/R Aluminum rod Batch: <u>1112328</u> | 0.00 | | | | | | | |
| *110* | | | | | | | | | |
| Large Fab | Memo | 0.00 | | | | | | | |
| Large Fab | WELD D4410-7 to D5046-3 AS PER DWG | | | | | | | | |
| 120 | QC9- Inspect visual per QSI004- Fusion Welds | 0.00 | | | | | | | |
| *120* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 130 | QC5- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *130* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

1 14-5-12

① 14-05-12 DAS 9 9:59

① 14-05-12 DAS 9 9:59

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Item ID: D5046-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Co-Pilot Collective Head Assembly (212)
 Start Date: 5/02/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 5/16/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------------|
| 140 | Outsource process-Anodize per OSI017 4.1.10.1 | 0.00 | | | | | | | |
| *140* | | | | | | | | | |
| Outsource4 | Memo | 0.00 | | | | | | | |
| Outsource process - Anodize | Issue P/O: <u>24/82</u> Black Anodize as per Dwg D5046 C OF C REQUIRED | | | | | | | | <u>CL 14/05/13 ①</u> |
| 150 | Receive & Inspect for Damage & Mat'l Certs | 0.00 | | | | | | | |
| *150* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | C OF C REQUIRED | | | | | | | | <u>P4/05/13 ①</u> |
| 160 | QC6- Inspect dimensions to drawing | 0.00 | | | | | | | |
| *160* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |

DAS
27
9-89
M/S/116

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Item ID: D5046-043 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Co-Pilot Collective Head Assembly (212)
 Start Date: 5/02/14 Start Qty: 1.00 ***1*** Cust Item ID:
 Required Date: 5/16/14 Req'd Qty: 1.00 ***1*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
| 170 | | 0.00 | | | | | | | |
| *170* | | | | | | 1 | | | FF 14-05-16 |
| Small Fab | Memo | 0.00 | | | | | | | |
| Small Fab | RE-PASS HELICOIL TAP IN THREADS AND INSTALL HELI-COIL ASSEMBLE AS PER DWG, ***Insert pin thru 1 side only*** | | | | | | | | |
| 180 | QCS- Inspect part completeness to step on W/O | 0.00 | | | | | | | |
| *180* | | | | | | | | | |
| QC | Memo | 0.00 | | | | | | | |
| Quality Control | | | | | | | | | |
| 190 | Identify as per dwg & Stock Location: _____ | 0.00 | | | | | | | |
| *190* | | | | | | | | | |
| Packaging | Memo | 0.00 | | | | | | | |
| Packaging | | | | | | | | | |

Kit D212-803-117 - Trans Aero/Roberts Aircraft PO 000212
 Do NOT send to anyone else!

50191
 50191

14/5/21

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Item ID: D5046-043

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Co-Pilot Collective Head Assembly (212)

Start Date: 5/02/14 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 5/16/14 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start *NR1*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

200

QC21 - Final Inspection - Work Order Release

0.00

200

QC

Memo

0.00

Quality Control

MLD 140521
MLD 14-05-21

Picklist Print

May-02-14 11:12:18 AM

Page 1

Work Order ID: 117788

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Parent Item: D5046-043

D5046-043

Parent Item Name: Co-Pilot Collective Head Assembly (212)

Start Date: 5/02/14

Required Date: 5/16/14

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP REV:A 14.04.11 NEW ISSUE DD VERF:JLM

| Component Item ID/ Item Name | Replacement Item ID | Mfg/ Purch | Bin Item | Primary Location | Last Location | Route Seq ID | Unit of Measure | Qty on Hand | Qty per Kit | Total Qty | Qty Issued | Date Issued | Status |
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|
|---------------------------------|------------------------|---------------|-------------|---------------------|------------------|-----------------|--------------------|----------------|-------------|--------------|---------------|----------------|--------|

D4410-7

Manufactured No

Each 16.0000

1

D4410-7

Conduit

Location

Loc Qty

Loc Code

117222X1

WA001

4

116127

4

WA002

12

117557

12

D5046-3

Manufactured No

Each 0.0000

1

D5046-3

Co-Pilot Collective Head

90296A108

Purchased No

Each 402.0000

5

90296A108

Heli-Coil Insert

Location

Loc Qty

Loc Code

ST391

402

m127878

52

m128972

250

m128990

100

5

EZ 145-12

EZ 145-12

FF 14-05-16

Picklist Print

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Work Order ID: 117788

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Parent Item: D5046-043

D5046-043

Parent Item Name: Co-Pilot Collective Head Assembly (212)

Start Date: 5/02/14

Required Date: 5/16/14

Start Qty: 1.00

Required Qty: 1.00

MS171539

Purchased

No

Each

72.0000

1

MS171539

Pin

Location

Loc Qty

Loc Code

ST331

7

123183

7

ST332

65

m128799

20

m128911

20

m128995

25

MS171599

Pin

Qty ① Batch: 123183

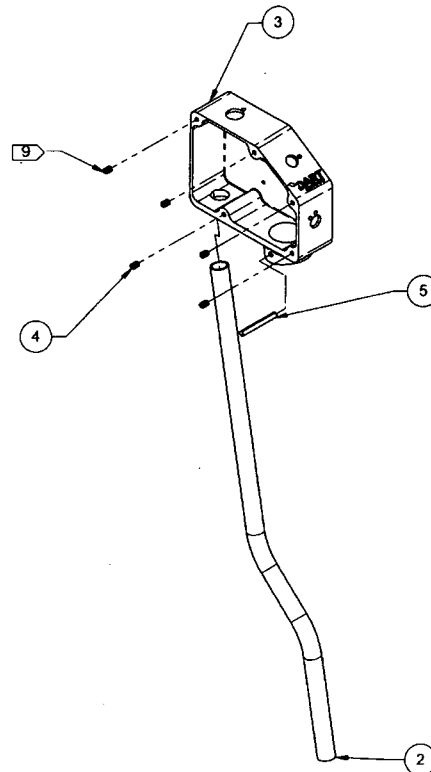
FF 14-05-16

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Shop Packet Print

Page 2

| ITEM | QTY -043 | P/N | DESCRIPTION |
|------|-------------|-----------|---|
| 1 | X | D5046-043 | CO-PILOT COLLECTIVE HEAD ASSEMBLY (212) |
| 2 | 1 | D4410-7 | CONDUIT |
| 3 | 1 | D5046-3 | CO-PILOT COLLECTIVE HEAD |
| 4 | 5 | 90296A108 | HELI-COIL INSERT (6-32 X 0.276) |
| 5 | 1 | MS171599 | PIN |



D5046-043 CO-PILOT COLLECTIVE HEAD ASSEMBLY (212)

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: ANODIZE BLACK PER MIL-A-8625F TYPE I OR IB OR IC OR II OR IIB CLASS 2 AFTER WELDING
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.1
- 7) WEIGHT: 0.90 lbs
- 8) WELD PER DART QSI 004
- 9) INSTALL AFTER ANODIZING

D5046-043 WELDING DETAIL

APPROVED

| | | | |
|------------|----------|---|---------------|
| DESIGN | VS | DART AEROSPACE USA, INC. | |
| DRAWN | VS | KENT, WA | |
| CHECKED | DC | DRAWING NO. | REV. A |
| MFG. APPR. | JFS | D5046 | SHEET 2 OF 12 |
| APPROVED | HS | TITLE | SCALE |
| DE APPR. | DS | CO-PILOT COLLECTIVE HEAD | NTS |
| DATE | 14.01.22 | <small>COPYRIGHT © 2014 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.</small> | |

RELEASED
2014-04-04



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO24189**

Purchase Order Date 5/13/2014

PO Print Date 5/16/2014

Page Number 2 of 5

Order From :

VC-ATG001

A.T.G. INDUSTRIES INC.
731 INDUSTRIELLE ROAD
ROCKLAND, ON K4K 1T2
CANADA

Ship To : DART AEROSPACE LTD

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

Contact Name

Vendor Phone 613-446-4544

Ship To Contact

Ship To Phone

Ship Via: VENDOR'S TRUCK

Ship Acct:

Buyer

Chantal Lavoie

Customer POID

Customer Tax # 10127-2607

Terms Net 30

Currency CAD

FOB FCA - (Free Carrier)

| | | | | | | |
|---|--------|----------------------------|-------------------------------|------|--------|--------|
| 3 | 117788 | D5046-043 CO-PILOT HEAD | 5/16/2014 Yes 5/16/2014 | 1.00 | \$6.25 | \$6.25 |
|---|--------|----------------------------|-------------------------------|------|--------|--------|

FINISH: BLACK ANODIZE PER MIL-A-8625F TYPE I OR
IB/IC/II/IB CLASS

RUSH ORDER

Line Total: \$6.25

| | | | | | | |
|---|--------|-----------------|-------------------------------|-------|--------|---------|
| 4 | 114186 | D2348 WEARPLATE | 5/16/2014 Yes 5/16/2014 | 20.00 | \$0.95 | \$19.00 |
|---|--------|-----------------|-------------------------------|-------|--------|---------|

FINISH: BLACK ANODIZE PER MIL-A-8625F TYPE I OR
IB/IC/II/IB CLASS

RUSH ORDER

Line Total: \$19.00

| | | | | | | |
|---|--------|-----------------|-------------------------------|-------|--------|---------|
| 5 | 115646 | D2348 WEARPLATE | 5/16/2014 Yes 5/16/2014 | 20.00 | \$0.95 | \$19.00 |
|---|--------|-----------------|-------------------------------|-------|--------|---------|

FINISH: BLACK ANODIZE PER MIL-A-8625F TYPE I OR
IB/IC/II/IB CLASS

RUSH ORDER

Note:

5/16/2014



A.T.G. Industries Inc.
731, rue Industrielle Rd.
PLATING DEPARTMENT
Rockland, On K4K 1T2
Canada
Ph: (613) 446-4544
Fax: (613) 446-4556

Pack List

Number: 63040

Date: 15-May-14

To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ship To

DART AEROSPACE LTD
1270 ABERDEEN ST.
HAWKESBURY, ON K6A 1K7
Canada

Ph: 613-632-5200

Fax: 613-632-1185

Ph: 613-632-5200

Fax: 613-632-1185

| Terms | | Ship Via | |
|---|--------------------|-------------|--|
| Quantity | | Description | |
| 1 lot | Part: ASST Rev: | | |
| 12 PCS D4726-1 (0.90) 4 PCS D5046-041 (6.25) 1 PC D5046-043 (6.25) 40 PCS D2348 (0.95) | | | |
| BLACK ANODIZE MIL-A-8625 TYPE II CLASS 2 | | | |
| PRICE IS PER PIECE Job: 20140292 PO: 24189 Line: | | | |
| Certificate of Conformance A.T.G. Industries certifies that all items in this shipment are in conformance with all requirements, specifications and drawings referenced in the purchase order. ISO 9001 : 2008 REGISTERED ATG SALES-2010 TERMS APPLY DATE: 15/05/14 CERTIFIED SIGNATURE: RECEIVER SIGNATURE: _____ | | | |